

Date: Thursday, 18/09/2008 11:12:47 AM
 User: Julie Lecocq

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOP PANEL ASS'Y
Job Number	: 42097		
Estimate Number	: 13034		
P.O. Number	:	Part Number	: D36509
This Issue	: 18/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3650 REV.B
First Issue	: / /	Project Number	: N/A
Previous Run	: 39951	Drawing Revision	: B
	Type	Material	:
	: SMALL /MED FAB	Due Date	: 25/09/2008
Written By	:	Qty:	5 Um: Each
Checked & Approved By	: <u>JUL 08.9.18</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC		
	: Est Rev:B ECN 1113P 08-01-22 DD verified by: EC		
	: Est Rev:C ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.2678 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108418 HB 8-9-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3650

Dwg Rev: B HB 8-9-22
 Prog Rev: B

(7)

2-Deburr if necessary HB 8-9-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

502/09/22 (77)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form as per Dwg D3650

HB 08/09/22 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASSY

Job Number: 42097

Part Number: D36509

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/09/08 (XZ)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: ST 115

JS 08/09/23 (XZ)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/09/24 (XZ)

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

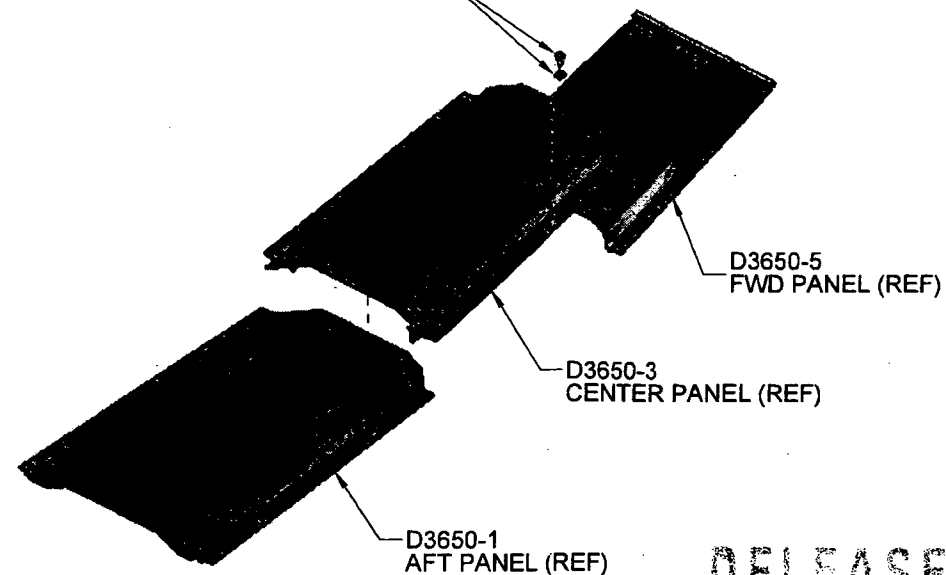
3

2

1

AN3C-3A BOLT (1)
AN960C10 WASHER (1)
(8 PLACES)

B

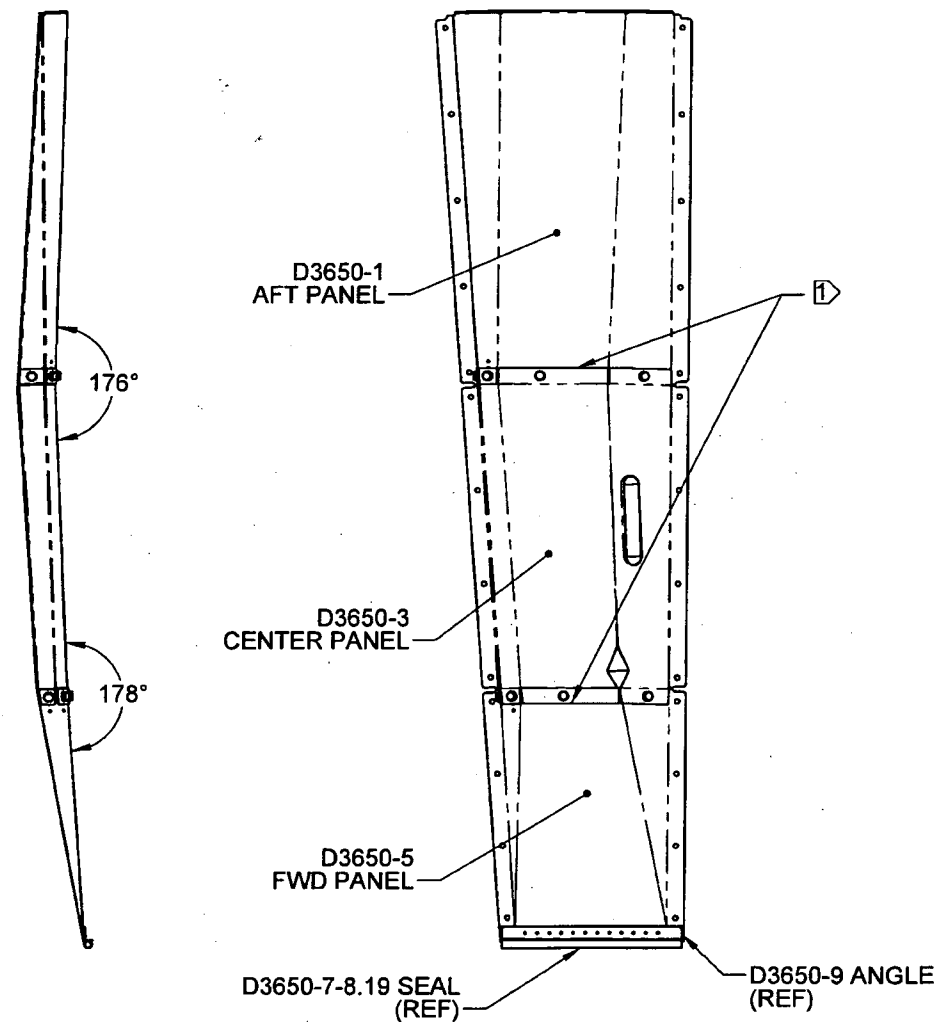


RELEASED
08-03-17/W

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B

**D3650-041 TUNNEL TOP PANEL ASSEMBLY**

NOTES:

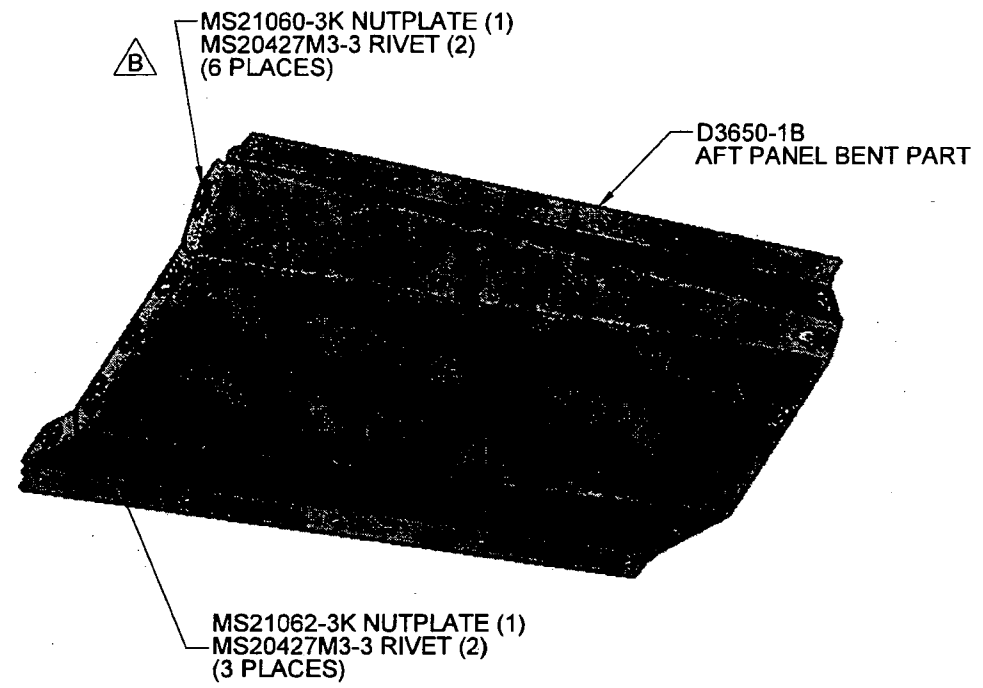
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3650	SHEET 1 OF 1 COPY
APPROVED	LE	TITLE	SCALE: RETURN TO
DE APPR.	LE	TOP PANEL ASSEMBLY	ENGINEERING
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

WITHOUT NOTICE
WORK ORDER
NO 42097

8 7 6 5 4 3 2 1

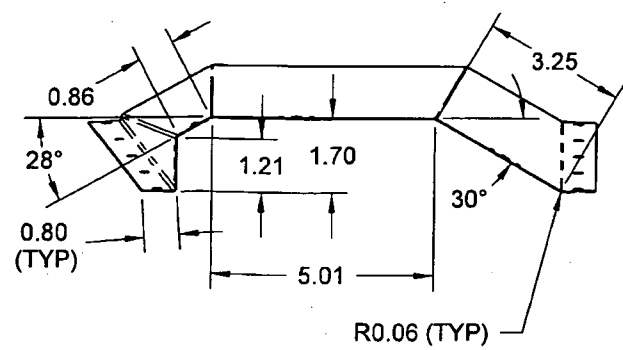
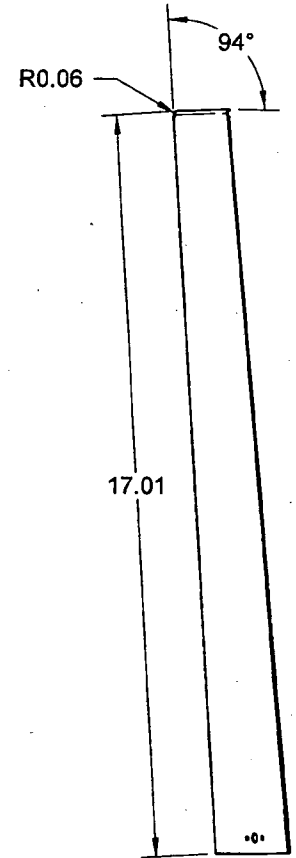
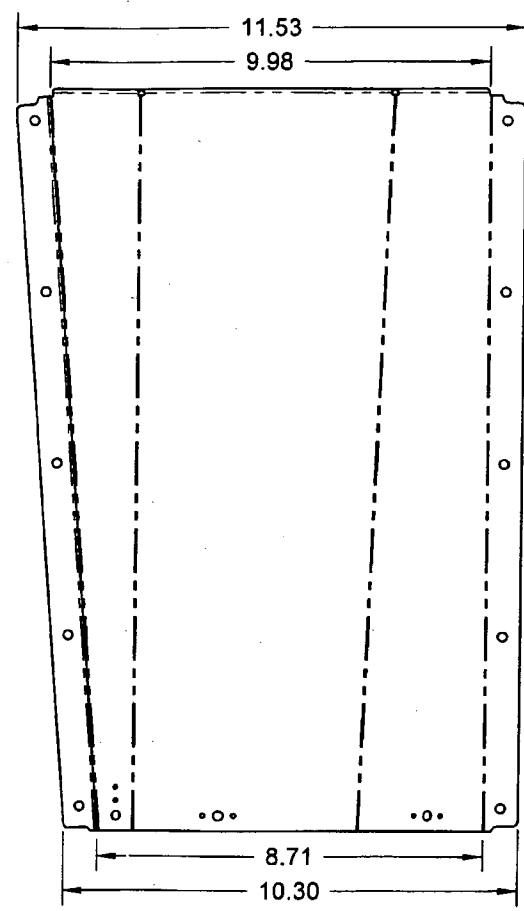
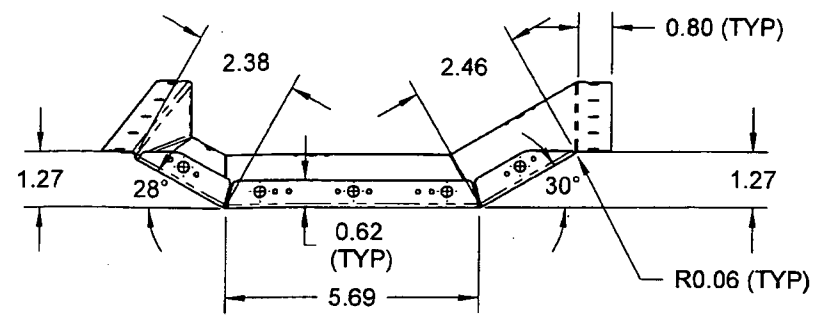


D3650-1 AFT PANEL

PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

- NOTES:
1) FINISH: NONE
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: NONE
6) WEIGHT: 1.3 lbs

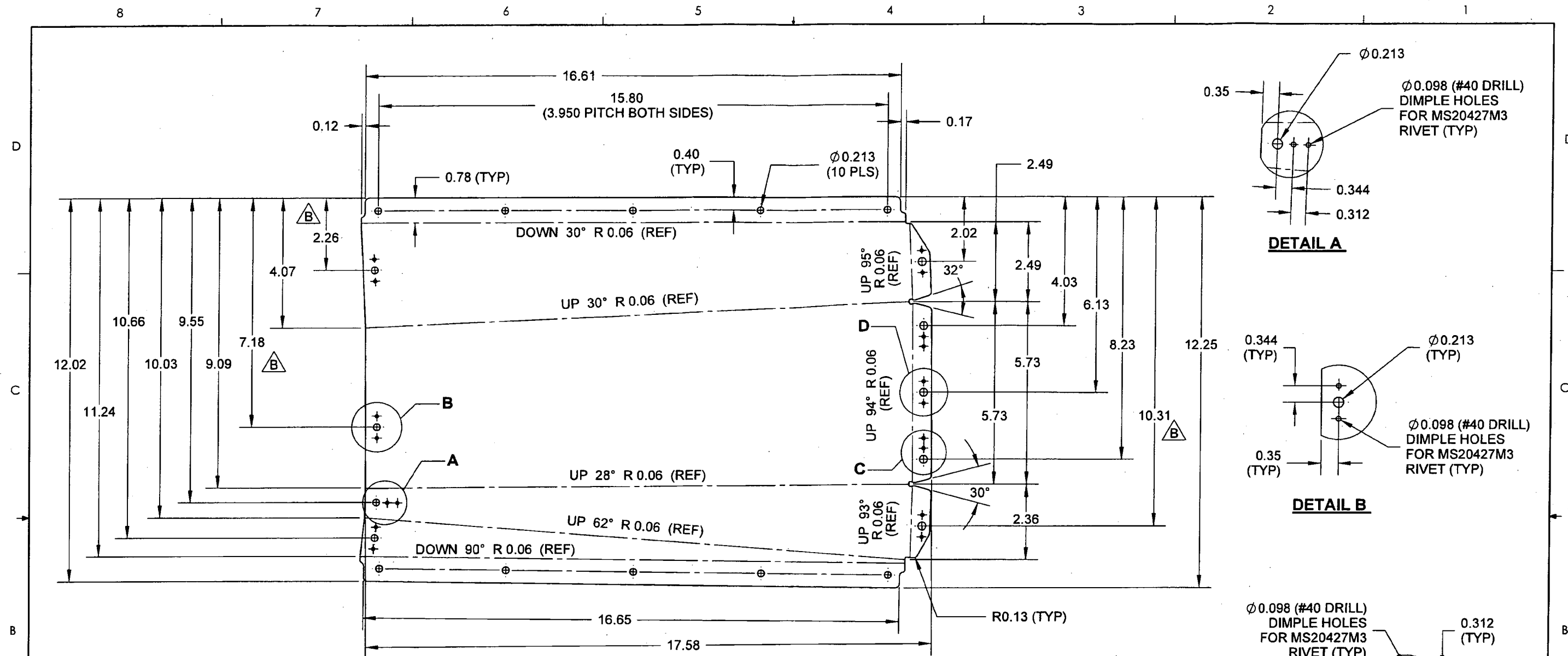


D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

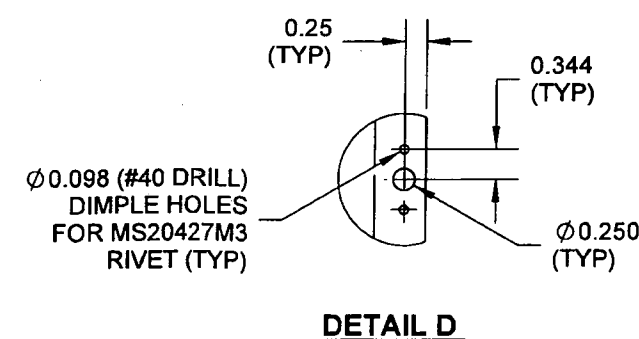
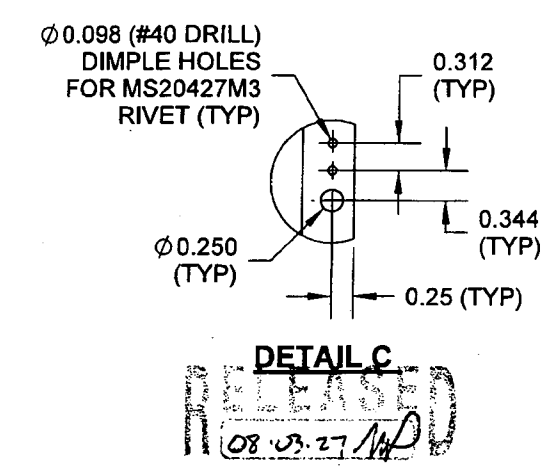
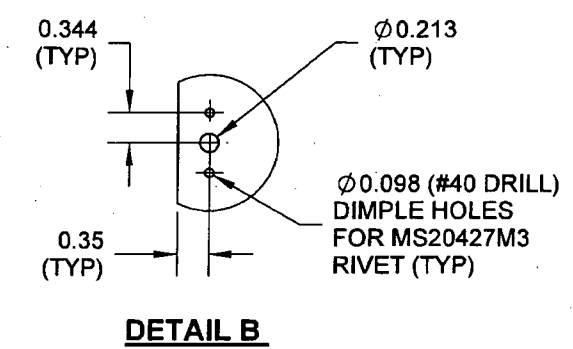
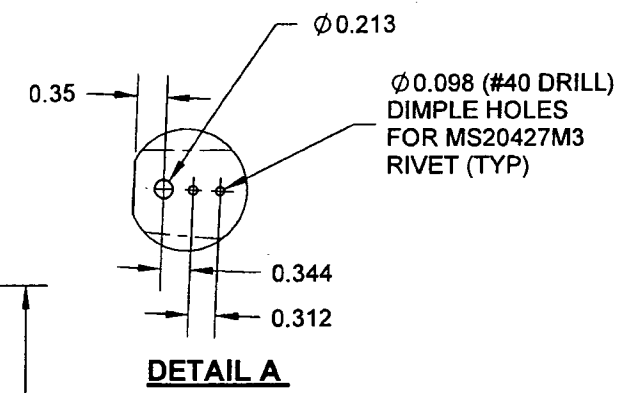
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08-03-27

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CHECKED	u	DRAWING NO. D3650
MFG. APPR.	MA	REV. B SHEET 2 OF 9
APPROVED	MP	TITLE TOP PANEL ASSEMBLY
DE APPR.	MP	SCALE 1:4
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


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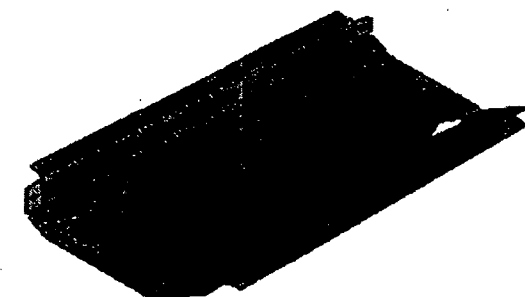
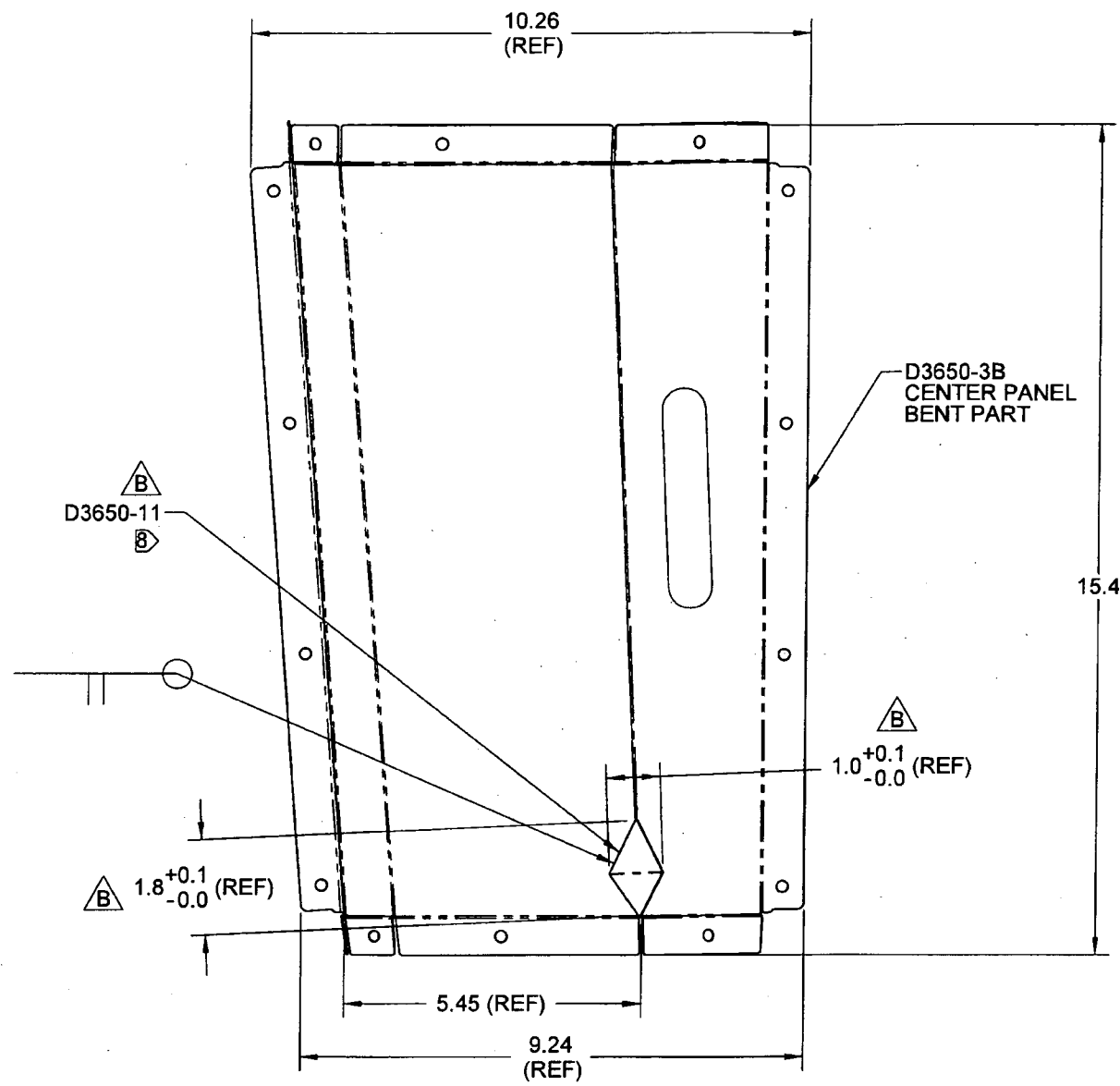
D3650-1F FLAT PATTERN



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.22 lbs

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MFG. APPR.		D3650	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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PART LIST

QTY	PART NUMBER	DESCRIPTION
3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

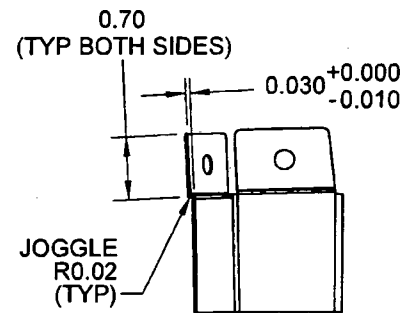
D3650-3 CENTER PANEL

- NOTES:**
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.0 lb
 - 8) TRIM D3650-11 TO FIT AS REQUIRED

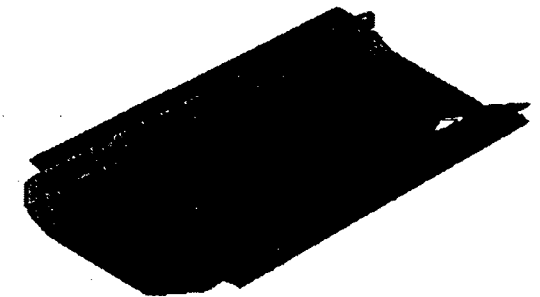
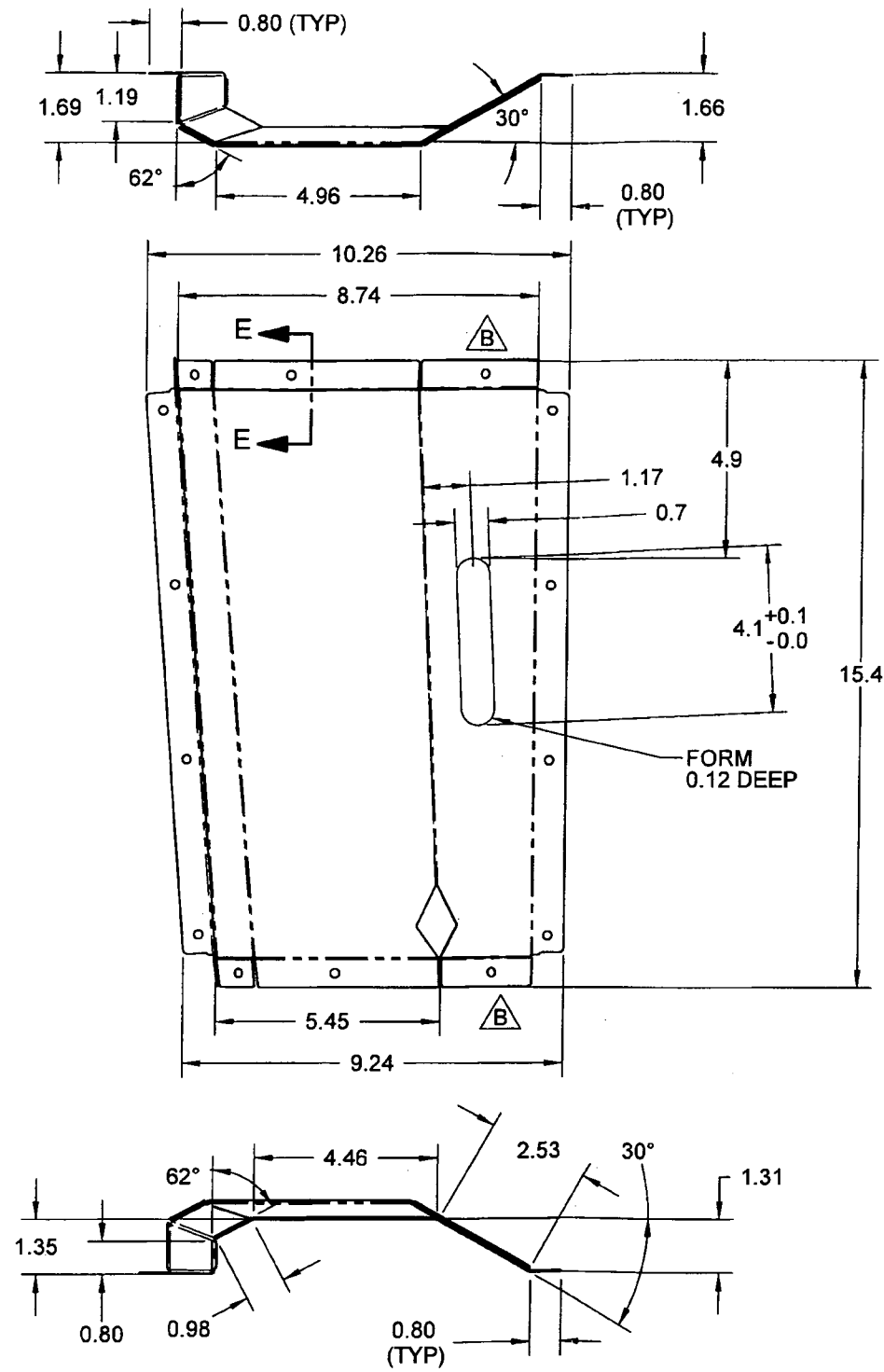
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08-03-27

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DRAWN	RF	
CHECKED	UC	DRAWING NO. D3650
MFG. APPR.		REV. B SHEET 4 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY
DE APPR.		SCALE 1:3
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SECTION E-E

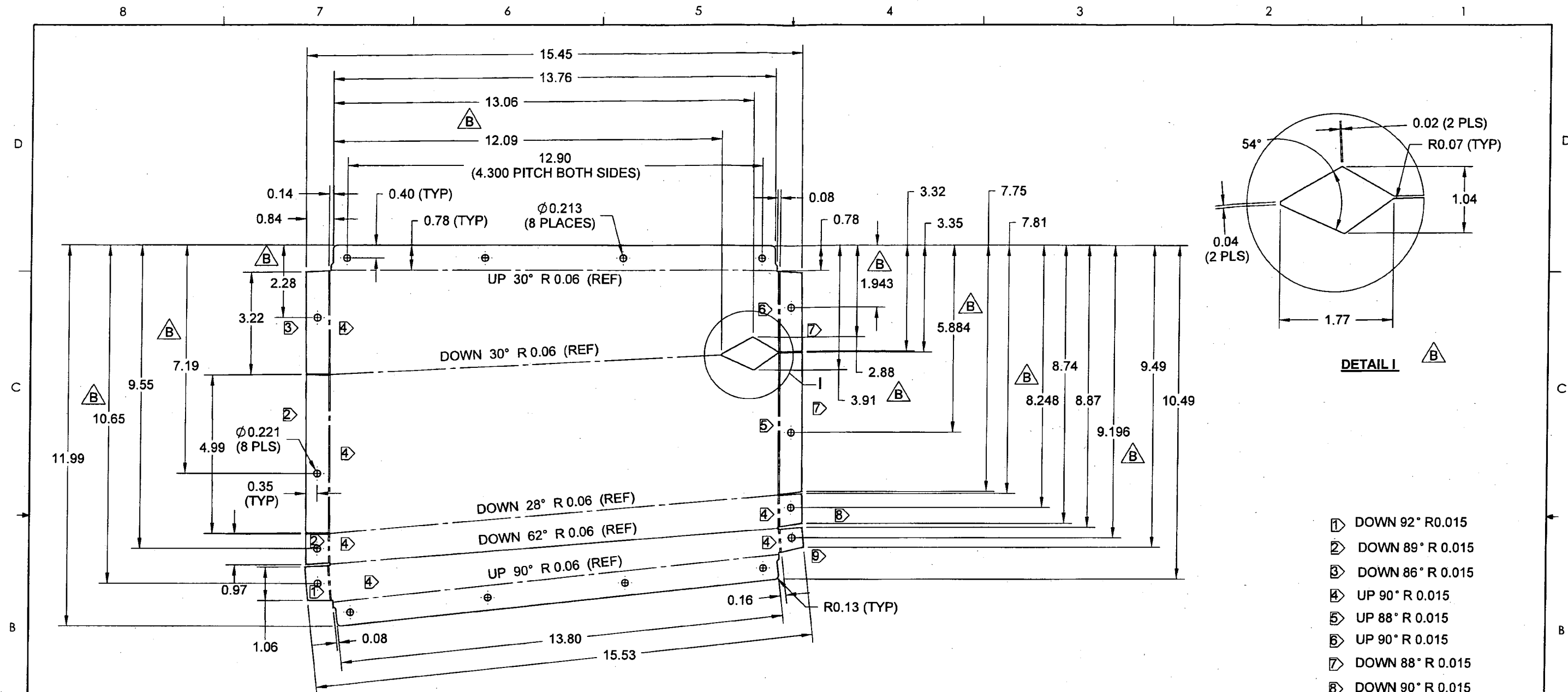


- NOTES:**
 1) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
 (MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D3650	REV. B
MFG. APPR.		SHEET 5 OF 9	
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE 1:4
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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D3650-3F CENTER PANEL FLAT PATTERN

- ① DOWN 92° R 0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

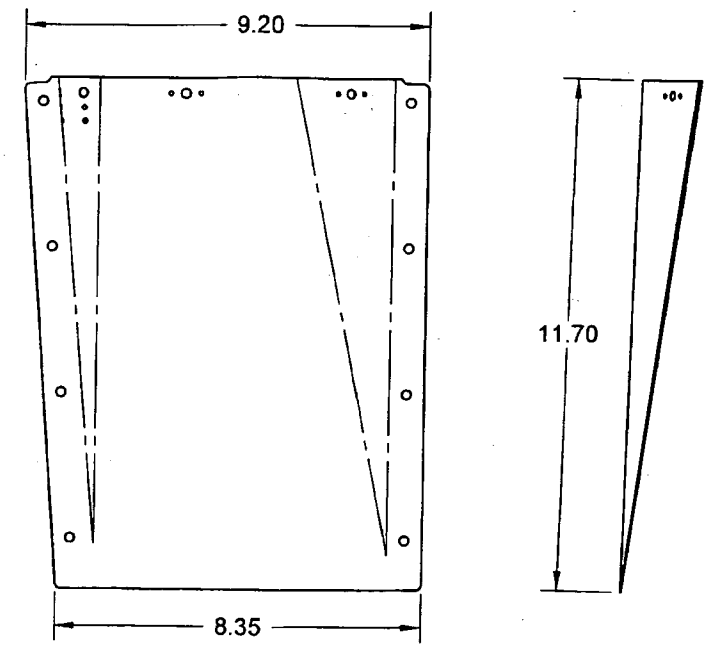
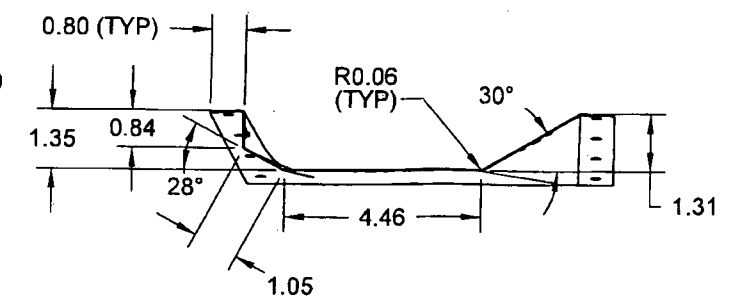
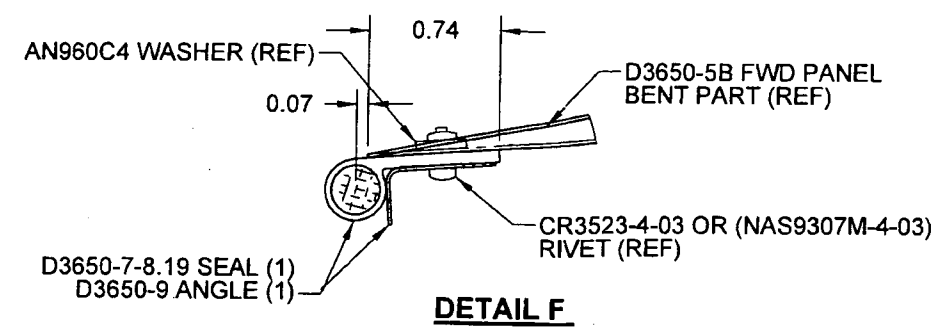
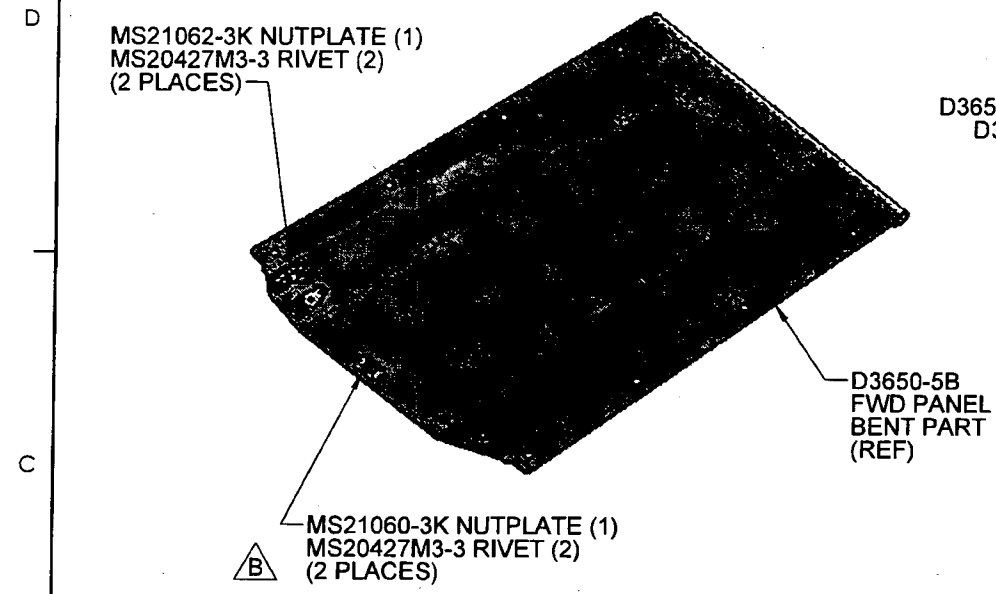
D3650-3F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3650	SHEET 6 OF 9
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	TOP PANEL ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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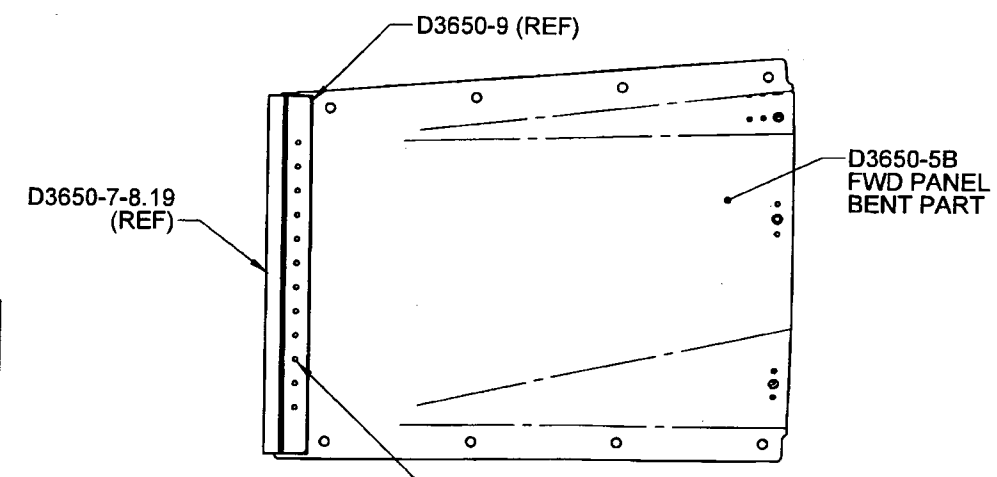
WITHOUT NOTICE
 WORK ORDER
 NO. 42017

8 7 6 5 4 3 2 1



PART LIST

QTY	PART NUMBER	DESCRIPTION
-5		
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE



D3650-5 FWD PANEL

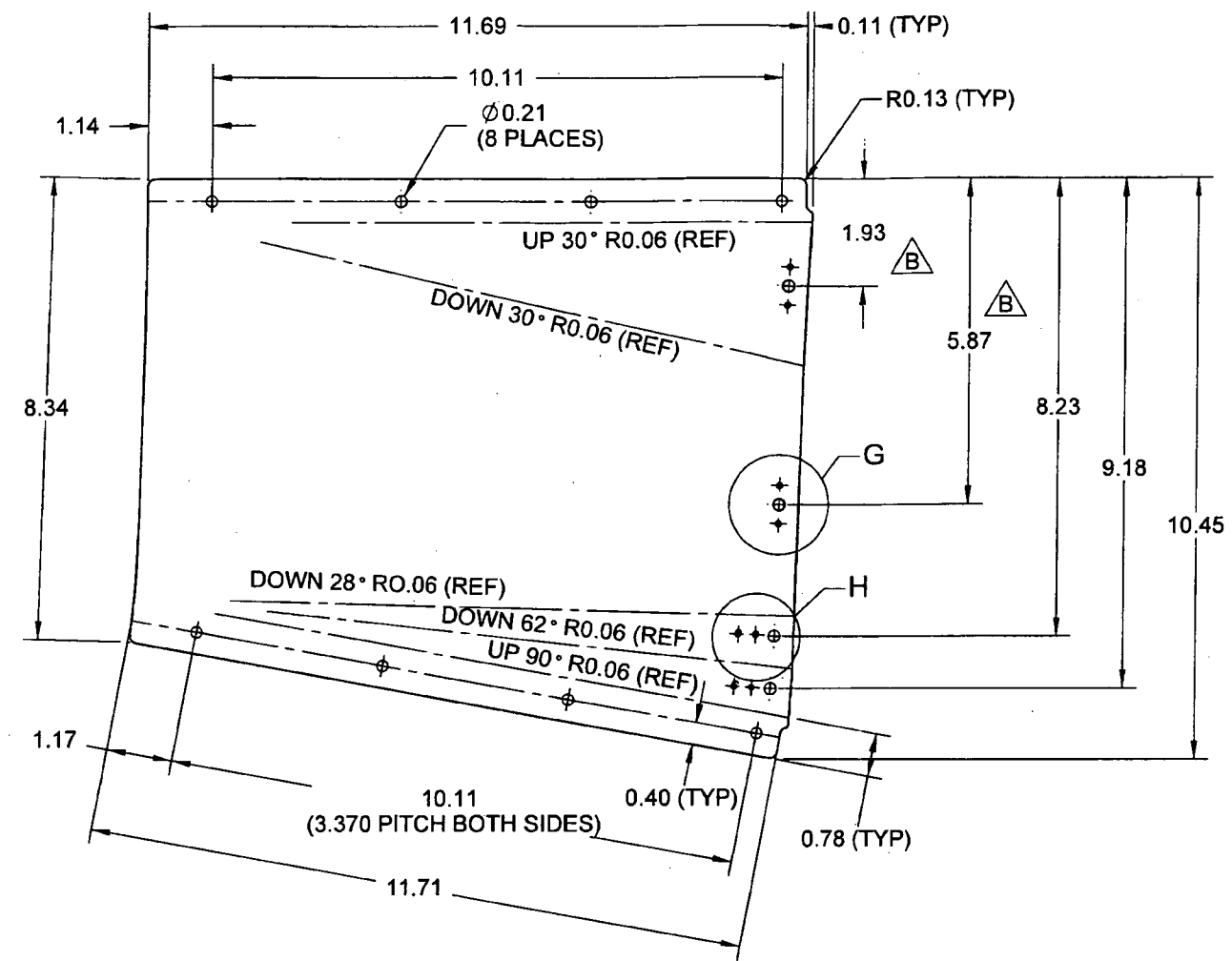
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.8 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	LE	DRAWING NO. D3650
MFG. APPR.		TITLE TOP PANEL ASSEMBLY
APPROVED		REV. B
DE APPR.		SHEET 7 OF 9
DATE	08.01.07	RETURN TO ENGINEERING
		WITHOUT NOTICE
		WORK ORDER NO. 42017

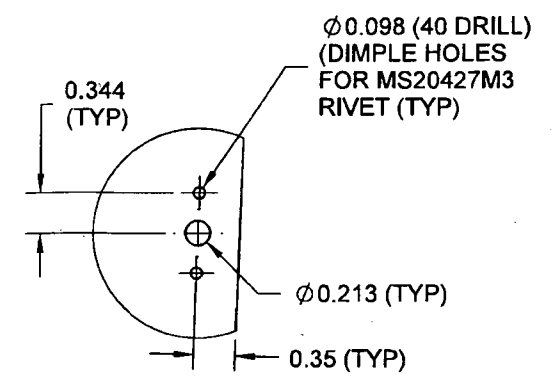
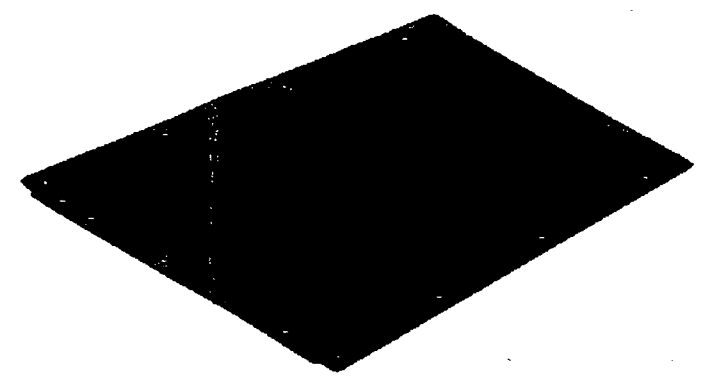
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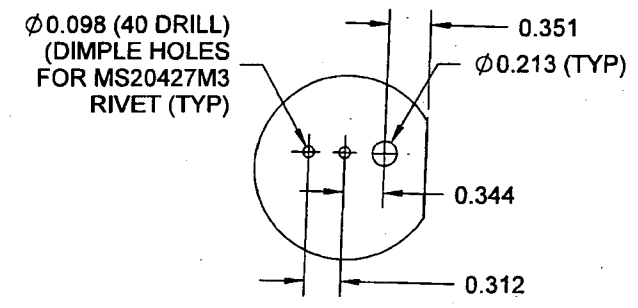
8 7 6 5 4 3 2 1



D3650-5F FLAT PATTERN



DETAIL G
(2 PLS)

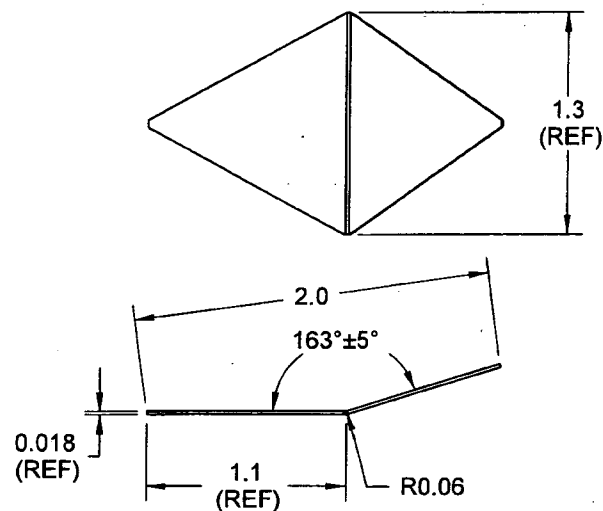


DETAIL H
(2 PLS)

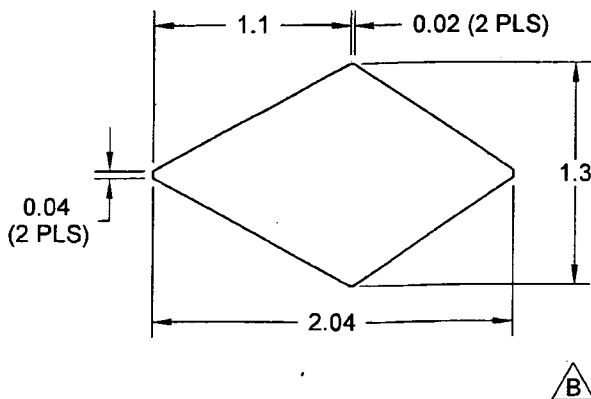
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:1
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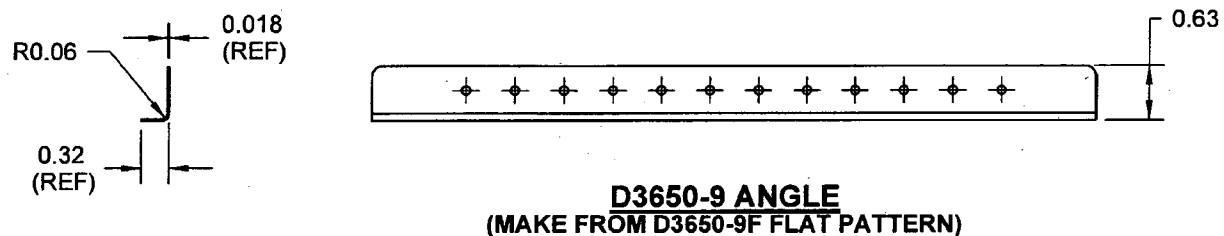
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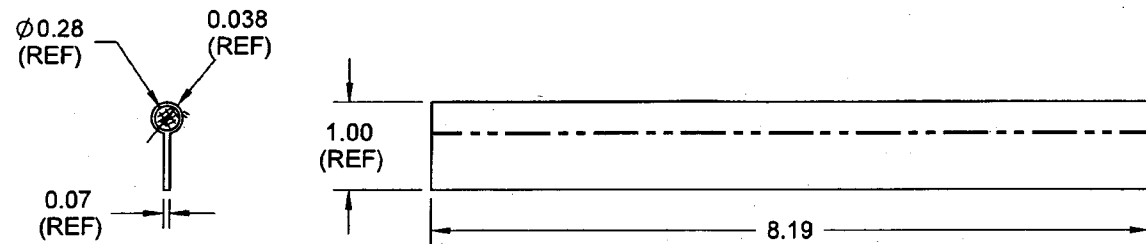
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



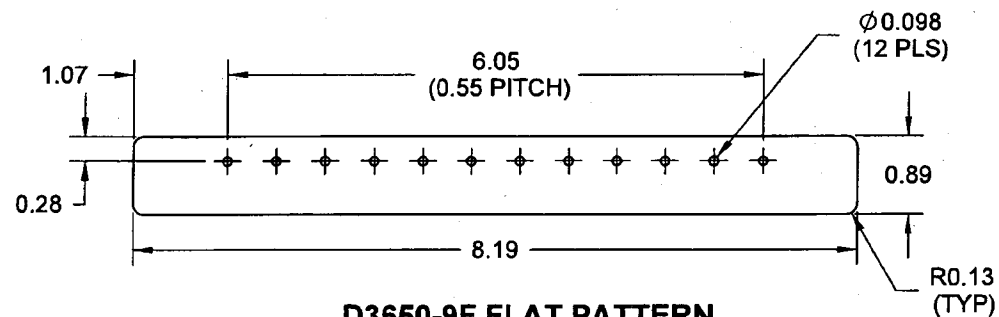
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3650	SHEET 9 OF 9
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	TOP PANEL ASSEMBLY	ENGINEERING
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